

## OK Flux 282

OK Flux 282 is an active, bonded flux designed for high speed, single pass welding of carbon steel sheet. Butt, lap, and fillet welds are well washed and free from undercut even at speeds up to 120 IPM (305 cm/min). It is primarily used with DC single and parallel wire systems at currents up to 1300 amps. OK Flux 282 is recommended for making high speed welds in metallic building beams, spiral pipe, storage tanks, and rail cars. \*Single pass application only. Any mechanical property and undiluted weld chemistry listed are for information only.

Specifications	
Classifications	ASME SFA 5.17 AWS A5.17 : F7AZ-EM12K AWS A5.17 : F7AZ-EM13K
Industry	Metal Beam Fabrication Pipe Construction Tank and Vessel Fabrication Railcars

Slag Type	ZS (Zirconium-Silicate)
Alloy Transfer	Very high silicon alloying and slightly manganese alloying
Density	nom: 1.33 kg/dm <sup>3</sup>
Basicity Index	nom: 0.3

Classifications	
Wire	AWS/EN
Spoolarc 29S	A5.17:EM13K

Approvals	
Combined with Wire	CWB
Spoolarc 29S	•
Spoolarc 81	•

Typical Wire Composition %					
C	Mn	Si	S	P	Cu
Spoolarc 29S					
0.08	1.15	0.5	0.006	0.013	0.06
Spoolarc 81					
0.09	0.95	0.26	0.01	0.01	-

Typical Weld Metal Analysis %									
C	Mn	Si	S	P	Ni	Cr	Mo	V	Al
Spoolarc 29S									
0.09	1.15	1.00	0.01	0.03	0.047	0.063	0.019	0.008	0.020
Spoolarc 81 As Welded									
0.05	1.14	0.67	0.013	0.040	0.05	0.07	0.02	-	-
Spoolarc 81									
0.09	1.24	0.80	0.02	0.03	-	-	-	-	-

Typical Weld Metal Analysis %			
Cu	Nb	Ti	Co
Spoolarc 29S			
0.143	0.005	0.020	0.007
Spoolarc 81 As Welded			

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### Typical Weld Metal Analysis %

Cu	Nb	Ti	Co
0.130	-	-	-